

Date: Thursday, 19/04/2007 11:09:13 AM  
 User: Linda Lacelle

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SPACEPOD FLOOR
Job Number	31836	Part Number	D31872
Estimate Number	10093	Drawing Number	D3187 REV. B
P.O. Number	N/A	Project Number	N/A
This Issue	19/04/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	B
First Issue	N/A	Material	N/A
Previous Run	31836	Due Date	30/04/2007
Written By	Qty: 20 Um: Each		
Checked & Approved By			
Comment	Est: C 05.04.14 Now a purchased part KJ/JLM Est Rev:D Now on Waterjet 07-04-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S050	6061-T6 .050 Sheet
Comment: Qty.: 7.8015 sf(s)/Unit Total: 156.0300 sf(s) 6061-T6 .050 Sheet 15.603 140.427 Batch: m104186 M17347 ml010520		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3187 Dwg Rev: B Prog Rev: B  ml010520		
Comment: FLOW WATER JET ml010520		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml010520		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 605.22 (19)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 4.1 Powder Coat Black Sandblasted. Fed/BK 07/06/05 (20) 4.2 QC3		

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Drawing Name: SPACEPOD FLOOR

Job Number: 31836

Part Number: D31872

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



07.06.07 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W07.06.07

(Pto)  
→

Date: Tuesday, 4/17/2007 11:05:15 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD FLOOR		
Job Number	: 31836		Part Number	: D31872		
Estimate Number	: 10093		Drawing Number	: D3187 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 4/17/2007	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	PURCHASED PARTS	Due Date	: 4/30/2007 Qty: 20 Um: Each	
Previous Run	: 25405					
Written By	:					
Checked & Approved By	:					
Comment	: Est: C 05.04.14		Now a purchased part	KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <i>Model 16500 SF X 43 SF Some 10/10/07 Merge</i>
2.0	D31872F	Spacepod Floor  <i>PRO</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>Comment: PACKAGING RESOURCE #1 Recieve &amp; Inspect for Transit Damage Ensure Material Release Note is attached</i>
4.0	QC6	DIMENSIONAL CHECK  <i>Comment: DIMENSIONAL CHECK</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Proj Mgr	Approval QC Inspector
07/05/22	4.0	Took 1, <del>18</del> to make a drill jig for the space pods, for D3187-2.	ml	07/05/22	1	07/05/22	07/05/22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:05:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR

Job Number: 31836

Part Number: D31872

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

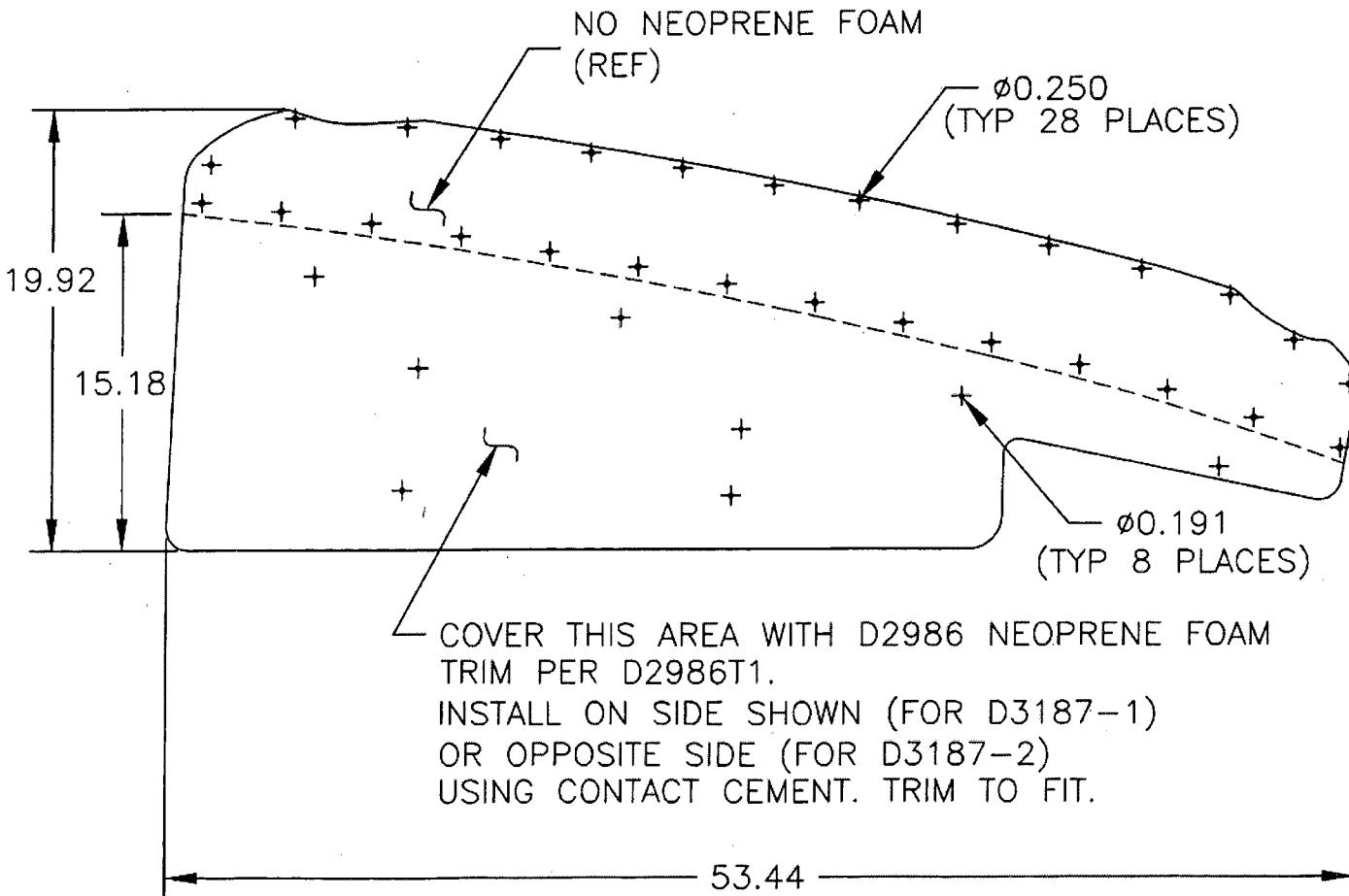
NOTE: Date & initial all entries



©COPY  
ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3187 SHEET 1 OF 1
DATE		TITLE SCALE 03.05.16 SPACEPOD FLOOR NTS
A	03.03.31	NEW ISSUE
B	03.05.16	CHANGE SHAPE

RELEASED  
03.06.25



#### D3187-1/-2 SPACEPOD FLOOR

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 31836

DART AEROSPACE LTD	Work Order:	31836
Description: <del>Seapaw</del> SpacePad Floor	Part Number:	D3187-2
Inspection Dwg: D3187 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.250$	$+0.005-0.001$	0.253	✓		vern	
B $\phi 0.191$	$+0.005-0.001$	0.193	✓		vern	
C 19.92	$+1-0.030$	19.92	✓		Measuring tape	
D 53.44	$+1-0.030$	53.44	✓		Measuring tape	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M.M	Audited by:	J	Prototype Approval:	N/A
Date:	01/05/20	Date:	01/05/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

